

Date: Tuesday, 5/16/2006 10:40:57 AM  
User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 206/OH-58 SADDLE, OUTBOARD, LEFT SIDE		
Job Number	: 27147					
Estimate Number	: 10831					
P.O. Number	: N/A			Part Number	: D29321	
This Issue	: 5/16/2006 S.O. No. : N/A			Drawing Number	: D2932 REV B	
Prsh Rev.	: NC			Project Number	: N/A	
First Issue	: N/A			Drawing Revision	: B	
Previous Run	: 26789			Material	: N/A	
Written By	<u>See Comment Below</u>			Due Date	: 6/5/2006	
Checked & Approved By	<u>JL 06.06.06</u>			Qty:	6 Um: Each	
Comment	: Est: B 00.08.26 New DWG rev, (mpp 2069) EC					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6101003	7075-T7351 2X6.25X7.875	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s) 7075-T7351 2X6.25X7.875 Issue material from stock: 7.88 7075-T7351 Cut Size 2.0 x 6.25 X 7.88 Grain Along Long 6.0 Length Batch No: <u>B25358</u> +6	
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Program part number and batch number. 1-Inspect part number and batch number are programmed correctly. 2-Machine Step No 1 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet 4-Machine Step No 3 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet 5-Deburr	<u>JL 06/06/06 +6</u>
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
		Comment: CONVENTIONAL MILLING MACHINE Machine Keyway and inspect per attached dimension sheet	<u>JL 06/06/06 +6</u>
4.0	QC1	INSPECT ALL DIM TO DIM SHEET	
		Comment: INSPECT ALL DIM TO DIM SHEET	<u>JL 06/06/06 +6</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
06/06/02		ADD a <del>s</del> Step for tumbling after QC8 (S.O) <u>Revised change</u>	En	06/06/02	1	06.06.02	06/06/02

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_

PAR #: \_\_\_\_\_

Fault Category: \_\_\_\_\_

NCR: Yes

 DQA: 

Date: 06/06/02

NOTE: Date &amp; initial all entries

QA: N/C Closed: \_\_\_\_\_

Date: \_\_\_\_\_

Date: Tuesday, 5/16/2006 10:40:57 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, OUTBOARD, LEFT SIDE

Job Number: 27147

Part Number: D29321

Job Number:



Seq. #:	Machine Or Operation:	Description :
5.0	QC8	SECOND CHECK 
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1 
7.0	POWDER COATING	POWDER COATING 
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION 
9.0	PACKAGING 1	PACKAGING RESOURCE #1 
10.0	DC	DOCUMENT CONTROL 

Comment: SECOND CHECK      Er 06/06/06 X6

Comment: HAND FINISHING RESOURCE #1  
Acid etch and Alodine as per QSI 005 4.1      SAB 06/06/06 6

Comment: POWDER COATING  
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3      A.M 06-06-06 (6)

Comment: INSPECT POWDER COAT      06/06/06 (6)

Comment: PACKAGING RESOURCE #1  
Identify and Stock  
Location: 474      06/06/06 (6)

Comment: DOCUMENT CONTROL  
Inspection Level 21      06/06/08 (6)

Job Completion      u 06/06/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

DART AEROSPACE LTD	Work Order:	27147
Description: 206 Saddle, Outboard, Left side	Part Number:	D2932-1
Inspection Dwg: D2932 Rev. B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. B and record below:

				Recorded Actual Dimensions						
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date	
A	0.100	0.140		.118	.122	.124	.124			
B	0.100	0.140		.118	.122	.122	.123			
C	0.100	0.140		.118	.117	.119	.122			
D	0.210	0.230		.215	.226	.225	.218			
E	1.245	1.255		1.250	1.250	1.250	1.250			
F	1.245	1.255		1.250	1.250	1.250	1.250			
G	2.495	2.505		2.501	2.500	2.500	2.501			
H	0.510	0.515		.513	.513	.513	.513			
I	1.572	1.582		1.577	1.577	1.578	1.571			
J	2.495	2.505		2.497	2.498	2.499	2.499			
K	0.257	0.262	DT8683	.258	/	/	/			
L	0.312	0.317	DT8686	.313	/	/	/			
M	0.235	0.240		.240	.239	.239	.239			
N	0.100	0.140		.105	.120	.119	.113			
O	0.540	0.560		.543	.544	.548	.544			
P	0.490	0.510		.501	.503	.503	.503			
Q	3.715	3.725		3.720	3.720	3.720	3.721			
R	2.470	2.510		2.499	2.498	2.498	2.500			
S	0.240	0.270		.251	.257	.259	.260			
T	0.100	0.180		.140	.140	.140	.140			
U	1.625	1.635		1.630	1.630	1.629	1.630			
V	1.362	1.372		1.367	1.367	1.367	1.367			
W	0.316	0.321	DT8690	.318	/	/	/			
X	1.125	1.145		1.128	1.135	1.133	1.129			
Y	1.565	1.585		1.568	1.573	1.571	1.569			
Z										
AA										
AB										
AC										
AD										
AE										
AF										
AG										
AH										
Accept/Reject										

Measured by:	SD / JL	Audited by:	EP
Date:	06/06/01	Date:	06/06/02

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	

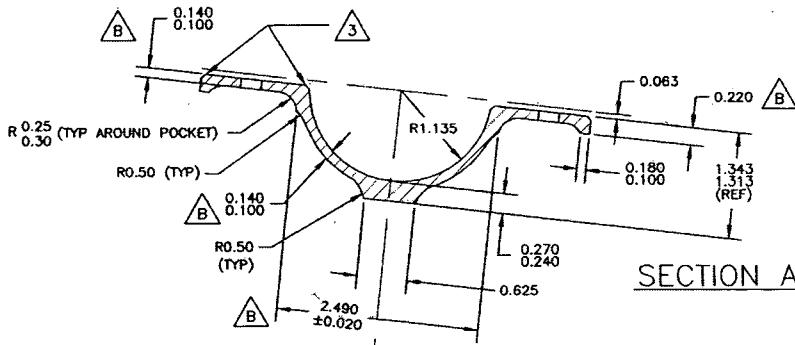
DART AEROSPACE LTD	Work Order:	27147
Description: 206 Saddle, Outboard, Left side	Part Number:	D2932-1
Inspection Dwg: D2932 Rev. B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. B and record below:

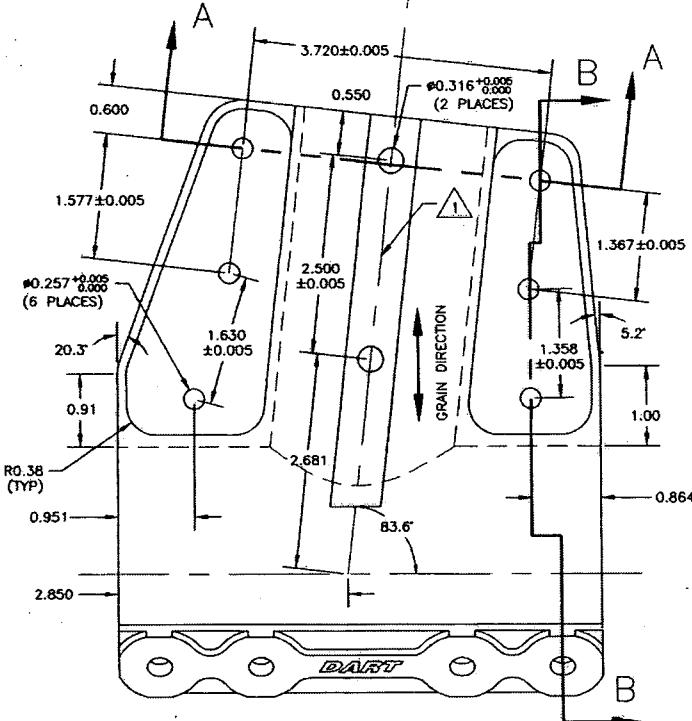
Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.120	.121				
B	0.100	0.140		.118	.120				
C	0.100	0.140		.125	.128				
D	0.210	0.230		.220	.216				
E	1.245	1.255		1.250	1.250				
F	1.245	1.255		1.250	1.250				
G	2.495	2.505		2.500	2.500				
H	0.510	0.515		.513	.513				
I	1.572	1.582		1.577	1.577				
J	2.495	2.505		2.500	2.800				
K	0.257	0.262	DT8683	/	/				
L	0.312	0.317	DT8686	/	/				
M	0.235	0.240		.238	.237				
N	0.100	0.140		.111	.110				
O	0.540	0.560		.548	.547				
P	0.490	0.510		.499	.498				
Q	3.715	3.725		3.719	3.719				
R	2.470	2.510		2.500	2.500				
S	0.240	0.270		.253	.256				
T	0.100	0.180		.140	.140				
U	1.625	1.635		1.630	1.630				
V	1.362	1.372		1.367	1.367				
W	0.316	0.321	DT8690	/	/				
X	1.125	1.145		1.137	1.130				
Y	1.565	1.585		1.571	1.570				
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	J.L.	Audited by:	EJ
Date:	06/06/02	Date:	06/06/02

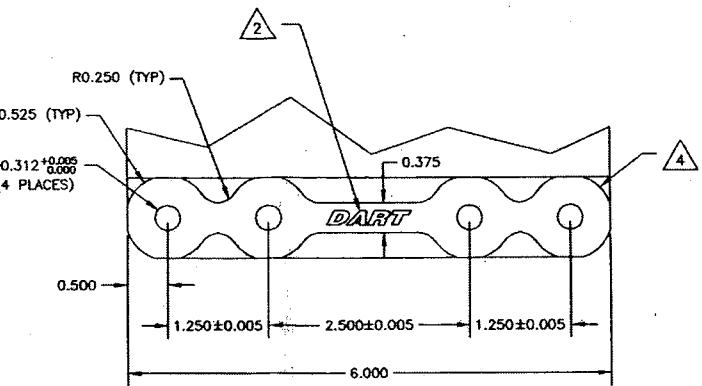
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	#



SECTION A-A



SECTION B-B



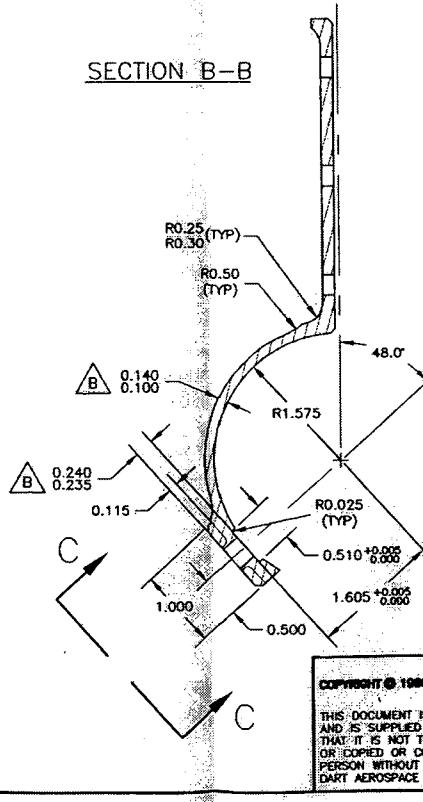
VIEW C-C

D2932-1 LH SADDLE (SHOWN)  
D2932-2 RH SADDLE (OPPOSITE)

MATERIAL: 7075-T7351 (00-A-250/12)  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER  
DART QSI 005 4.3  
BREAK ALL SHARP EDGES 0.010 TO 0.020  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP
- 2 ENGRAVE DART LOGO TO MAX DEPTH OF 0.005 WITH MIN RAD 0.250
- 3 CHAMFER 0.050" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 4 CHAMFER 0.050" x 45°

RELEASED  
60.05.31



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B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC. REV. B
CHECKED	APPROVED	DRAWING NO. D2932
DATE		TITLE SADDLE OUTSIDE
00.05.29		SCALE 2-3

NO. 2747  
WORK ORDER  
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